Work Orde Friday, June 04,											Page 1
Item ID:	K10003			Accept				s	etup Sta	rt	
Revision ID:						::: -::	121 JISJI SEIJI				
Item Name:	Saddle, D205-	634-011							Sto	р	
Start Date:  Required Date:	6/4/2010 6/10/2010	Start Qty: 8.00 Req'd Qty: 8.00			Cust Item I Customer:	D:					
Reference:			,								
Approvals:	Process Pla	n:	Date: 10-6-0	Tooling:	D:	ate:		R	tun Sta		
	QC:		Date:	_ SPC (Y/N):	Da	ate:			Sto		
Sequence ID/ Work Center ID	)	Operation Description	· · · · · · · · · · · · · · · · · · ·	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
IIN634,635	Rev	F									
100				0.00							
		DOCUMENT CÓNTRO	OL			*		1	1 1	1-6-0	11
DC		Memo		0.00				12	J	_ • • • •	7
Document Control		Create Whi	ite labels only per PPP K10	0003 CHG 007	•						
		Pick Kit		0.00				th = 6	~ 10	-000	2

Packaging

Packaging

Memo

0.00

120

QC4- 100% Inspect kits for completeness

Memo

Quality Control

Dart	Aeros	pace	Ltd
------	-------	------	-----

W/O:			WC	RK ORDER CHANG	ES			•	<b></b>		
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
				•							
Part No		PAR #:									
		solution:	Disposition	າ:	_ QA: N/C Clo	sed:		Date:	·		
NCR:	,		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section  Action Description  Chief Eng	on B Sign & Date	Verificat Section		Approval Chief Eng	Approval QC Inspector 1		
						1,100					
									/		
								•			
				Mr.							
							l				

## Work Order ID 59443

Friday, June 04, 2010 10:29:01 AM



Page 2

Item ID:

K10003

Accept



Setup Start



**Revision ID:** 

Item Name:

Saddle, D205-634-011

**Start Date:** 6/4/2010 **Required Date: 6/10/2010** 

Start Qty: 8.00

Req'd Qty: 8.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvais.	

Process Plan: \_\_\_\_\_

Date:

Tooling:

Date:

Run

Start

Stop



Annrovale

QC:

Date:\_\_\_\_\_

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

130



Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location

Memo

Set Up/ Run Hours

0.00

Tool ID

Tool # Plan

Code

Accept

Qty

Reject Qty

Reject Insp. Number Stamp

140

OC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

0.00

10/06/17/c 10-6-

Dart	Aero	space	Ltd
------	------	-------	-----

W/O:			WC	RK ORDER CHANG	3FS				•	
DATE	STEP	PRO	OCEDURE CHAI	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
						A		4.00		
Part No	•	PAR #:	Fault Cate	norv:	NCP: Vos	No. DO		Data		
						QA: N/C Closed: Date:				
NCR:				R NON-CONFORM						
DATE	STEP	Description of NC	Initial		etion B	Verific		Approval	Approval	
		Section A	Chief Eng	Action Description Chief Eng	Sign 8 Date		on C	Chief Eng	QC Inspector	
				•						
	,									

#### **Picklist Print** Page 1 Friday, June 04, 2010 10:29:09 AM Work Order ID: 59443 Parent Item: K10003 Parent Item Name: Saddle, D205-634-011 **Start Date:** 6/4/2010 Required Date: 6/10/2010 IPP: I□ 03.01.16 Reformat: Incorporated D205-641-011 Comments: KJ/RF□ Start Qty: 8.00 Required Oty: 8.00 IPP: J 06-07-25 As per DSI 9344 JLM IPP: K 06.11.17 Per K10003 Rev C KJ IPP: L 07.01.12 Document Record for copying bluefile rmv KJ M114941 10.6.25 39 'AN4-51A Purchased No 110 Each 88.0000 Location Loc Qty Loc Code ST361 88 112720 2 113121 1 114495 85 AÑ4-6A / Purchased No 110 Each 788.0000 Location Loc Oty Loc Code ST356 788 112933 96 113149 600 114523 2 114615 89 AN4C47A Purchased No 110 Each 53.0000

Loc Oty

53

53

Loc Code

Location

114653

ST361

Dart A	erospace	Ltd
--------	----------	-----

W/O:		·	WO	RK ORDER CHANG	ES			Ē.	
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						1.		<u> </u>	
								-	
Part No	•	PAR #:	Fault Cate	Jory:	_ NCR: Yes	No DQ	A:	Date:	
		esolution:							
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCI	₹)			
DATE	STEP	Description of NC		Corrective Action Secti		Verific	ation	Approval	Approval
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Secti		Chief Eng	QC Inspector
	Į.								
									•

Friday, June 04, 2010 10:29:09 AM

Page 2

Required Date: 6/10/2010

Required Qty: 8.00

Work Order ID: 59443

K10003

Parent Item Name:

Saddle, D205-634-011

Comments:

Parent Item:

IPP: I□ 03.01.16 Reformat: Incorporated D205-641-011

IPP: J 06-07-25 As per DSI 9344

IPP: K 06.11.17 Per K10003 Rev C

KJ/RF□

JLM

KJ

AN6-12A

IPP: L 07.01.12 Document Record for copying bluefile rmv KJ

Purchased

No

110

Each

118.0000

**Start Date:** 6/4/2010

Start Qty: 8.00

				12314 14523		Loc Oty 118 18 100	Loc Code		18	107
AN960JD416 NAS1149D0463J Washer	Purchased	No			110	Each	0.0000	32	15256 MILYS 76	
	Purchased	No			110	Each	0.0000	8	64 y MII 3524	M1173-6 10.6-142
D2570 }	Manufactured	No			110	Each (de+	94.0000	24	192/00× B59417	10-6-14 Sf 8x
			<b>Location</b>	. ,		Loc Oty	Loc Code		B59593	922

ST018

W/O:			WC	ORK ORDER CHANG	ES				t.	. 9
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				,					1 Tod Wigi	
				27.00					Andrew Co.	
									,	
Part No	:	PAR #:	Fault Cate	gory:	_ NCR	: Yes I	No <b>DQ</b>	<b>4</b> :	_ Date: _	
	Re	esolution:	Dispositio	n:	QA:	N/C Cld	sed:		Date:	
NCR:		· .	WORK ORD	ER NON-CONFORM	ANCE	(NCR	)			
DATE	STEP	Description of NC			tion B	0: 0	Verific	ation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti	on C	Chief Eng	QC Inspector
		,							; ;	
•										
			·							

Friday, June 04, 2010 10:29:09 AM

Work Order ID: 59443 K10003 Parent Item: Parent Item Name: Saddle, D205-634-011 **Start Date:** 6/4/2010 **Required Date:** 6/10/2010 Required Qty: 8.00 Comments: IPP: I□ 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF□ Start Qty: 8.00 IPP: J 06-07-25 As per DSI 9344 JLM IPP: K 06.11.17 Per K10003 Rev C ΚJ IPP: L 07.01.12 Document Record for copying bluefile rmv KJ D2571 110 Manufactured Each 13.0000 Saddle, Fwd Out 205 Location Loc Qty Loc Code ST425 43564 47564 ST433 2 D2572 Manufactured 110 7.0000 No Each Location Loc Qty Loc Code ST425 43565 4 ST433 3 3 58668 D2573 Manufactured No 110 Each 9.00004 Saddle, Aft Out 205 Location Loc Qty Loc Code ST425 43566 47566 ST434

W/O:  DATE STEP PROCEDURE CHANGE  By Date Qty Chief Eng / Prod Mgr	Approval QC Inspector
Part No: PAR #: Fault Category: NCR: Yes No DQA: Date: _	
Resolution: Disposition: QA: N/C Closed: Date: _	
NCR: WORK ORDER NON-CONFORMANCE (NCR)	
DATE STEP Description of NC Corrective Action Section B Verification Approval	Approvai
Section A Initial Action Description Sign & Section C Chief Eng Ch	QC Inspector
	-

Friday, June 04, 2010 10:29:09 AM Work Order ID: 59443 Parent Item: K10003 Parent Item Name: Saddle, D205-634-011 Start Date: 6/4/2010 Required Date: 6/10/2010 Comments: IPP: I□ 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF□ Start Qty: 8.00 Required Qty: 8.00 IPP: J 06-07-25 As per DSI 9344 JLM IPP: K 06.11.17 Per K10003 Rev C KJ IPP: L 07.01.12 Document Record for copying bluefile rmv KJ D2574 Manufactured No 110 5.0000 Each Location Loc Qty Loc Code ST425 43567 ST434 58252 D2747 Manufactured No 110 Each 81.0000 Location Loc Qty Loc Code ST023 81 39224 4 77 51921 Manufactured No 110 Each 77.0000 Location Loc Oty Loc Code ST028 77 30 51540 47 Manufactured No 110 72.0000 Each Location Loc Qty Loc Code ST028 72

. 9

63

51541

	•									
W/O:			WC	ORK ORDER CHANG	GES				••	n 13a
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										į
Part No	:	PAR #:	Fault Cate	gory:	NCR:	Yes N	No DQ	<b>4</b> :	Date:	
			Disposition: 0							
NCR:			WORK ORDI	ER NON-CONFORM	ANCE	(NCR)				
DATE	STEP	Description of NC	Corrective Action Section			Veritic			Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	& Section C		Chief Eng	QC Inspector
						- 1 White				
								į		
		\								

Friday, June 04, 2010 10:29:09 AM

Page 5

Work Order ID: 59443

K10003

Parent Item Name:

Saddle, D205-634-011

**Comments:** 

Parent Item:

IPP: I□ 03.01.16 Reformat: Incorporated D205-641-011

IPP: J 06-07-25 As per DSI 9344

IPP: K 06.11.17 Per K10003 Rev C

IPP: L 07.01.12 Document Record for copying bluefile rmv KJ

Start Date: 6/4/2010

Required Date: 6/10/2010

Start Qty: 8.00

Required Qty: 8.00

D3405-041

Lug Assembly

Manufactured No

Manufactured

Manufactured

No

No

110

KJ/RF□

JLM

ΚJ

Each

8.0000

D3405-043

Lug Assembly

Location ST474

57726

Loc Oty 110 Each

10.0000

Loc Code

D3407-041

Location ST474

Location

53888 57727 10 1 9

Each

Loc Qty

Loc Code

6.0000

Loc Code

Manufactured No ST464 58209

110 Each

Loc Qty

83.0000

Location Loc Qty Loc Code ST056

110

52344 59250

W/O:				VODY ODDED OF	1411050							
W/O:	T			VORK ORDER CI	HANGES			,				
DATE	STEP	PRO		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
					I							
					· · · · · · · · · · · · · · · · · · ·							
		PAR #:	Fault Ca	tegory:	NC	R: Yes	Vo DQ	DQA: Date:				
Resolution:									Date:			
NCR:			WORK OR	DER NON-CONF	ORMANCE	(NCR	)		-			
DATE	STEP	Description of NC	Corrective Action Sec				Verific	ification Approval		Approval		
DAIL	SILF	Section A	Initial Chief Eng	Action Descr Chief Eng	iption	Sign & Date		on C	Chief Eng	QC Inspector		
		•										
					· · · · · · · · · · · · · · · · · · ·							
					.*							

Friday, June 04, 2010 10:29:09 AM

Page 6

Required Date: 6/10/2010

Required Oty: 8.00

Work Order ID: 59443

K10003



Parent Item Name:

Saddle, D205-634-011

Comments:

Parent Item:

IPP: I□ 03.01.16 Reformat: Incorporated D205-641-011

Manufactured

Purchased

IPP: J 06-07-25 As per DSI 9344

IPP: K 06.11.17 Per K10003 Rev C

IPP: L 07.01.12 Document Record for copying bluefile rmv KJ

KJ/RF□

JLM

KJ

D3456-1. /

Manufactured No 110

Each

123.0000

**Start Date:** 6/4/2010

Start Qty: 8.00

S / Washer

Set Screw

MS21042L4

LO Nut

No

No

ST058 54692

Location

Loc Qty 123

Each

123

110

107.0000

Loc Code

Loc Oty Location Loc Code ST069 107 107

51602

9063

110

Each

4,043.000

Location Loc Qty Loc Code ST139 2 111827 2 ST300 4041 113422 68 114523 965 114718 1000 114784 2000

Dart A	erospace	Ltd
--------	----------	-----

W/O:			WO	RK ORDER CHANG	GES				e	* · · · · ·	
DATE	STEP	PRO	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
									·		
Part No	<u> </u>	PAR #:	Fault Cated	lory.	NCB: Y	/os N	do <b>DO</b>	۸-	Data		
						NCR: Yes No DQA: Date: QA: N/C Closed: Date:					
NCR:		<del></del>		R NON-CONFORM							
DATE	STEP	Description of NC	Initial	tion B	ign &	Verification		Approval	Approval		
		Section A	Chief Eng	Action Description Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector	

Friday, June 04, 2010 10:29:09 AM

Page 7

Work Order ID: 59443

Parent Item:

K10003



Parent Item Name:

Saddle, D205-634-011

IPP: I 03.01.16 Reformat: Incorporated D205-641-011

IPP: J 06-07-25 As per DSI 9344

IPP: K 06.11.17 Per K10003 Rev C

IPP: L 07.01.12 Document Record for copying bluefile rmv KJ

KJ/RF□

JLM

KJ

MS21043-4

Comments:

III

Purchased

No

110

Each

1,595.000

5 1**11**1

**Start Date: 6/4/2010** 

Start Qty: 8.00

10-6-14 20

(82)

Required Date: 6/10/2010

Required Qty: 8.00

Loc Qty Location Loc Code FG 40 104603 40 ST301 1555 112492 25 113069 8 114181\_\_ 222 114348 500 114523. 500 114784 300

<b>Dart Aeros</b>	pace Ltd
-------------------	----------

W/O:		WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE By Date Q						Approval QC Inspector				
19-24-0				1 + 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 -								
-		8		.,								
Part No		PAR #:										
	R	esolution:	Dispositi	on:	QA: N/C Clo	QA: N/C Closed: Date: _						
NCR:		WC	ORK ORE	DER NON-CONFORMA	NCE (NCR	)						
DATE	STEP	Description of NC	Corrective Action Section B			Verification	n Approval	Approval				
DAIL	SIEF	Section A	Initial Action Descript Chief Eng Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspector				
•												
							!					
	,						1					



**D205-634** Page 10 of 10

#### 5.0 PARTS LIST

5.0	1 71	13 LIS	- · ·							
Item	634 -011	634 -015	634 -041	634 -045	641 -011	Part Number	Description			
	X			-		D205-634-011	SKIDTUBE INSTALLATION (STANDARD)			
		Х				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)			
	1		X			D205-634-041	SKIDTUBE			
		1		Х		D205-634-045	SKIDTUBE			
	1	1			Х	D205-641-011	GROUND HANDLING KIT			
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)			
1				1		D2580-041	205 SKIDTUBE ASSEMBLY (MODIFIED)			
2A			16	16		D2594-1	* PLUG			
2B			16	16		D2594-3	* O-RING			
3			1	1		D2855	* AFT CAP			
4	4 7 7		2	2		AN3-5A	* BOLT			
5			2	2		AN960JD10L	*WASHER			
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)			
6B			1	1		D3566-1	* GASKET			
7A			1	1 .		D3564-11	* WEARSHOE (REPLACES D2577-3)			
7B			1	1 .		D3566-1	* GASKET			
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)			
8B			1	1		D3566-5	* GASKET			
9A			1	1		D3564-13	* WEARSHOE			
9B -	,		1	1	-	D3566-13	* GASKET			
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)			
11			50	50		AN960C10L	* WASHER (REPLACES AN960JD10L)			
12			50	50		ALS4-1032-130	* INSERT			
13			2	2 .		ALS4-1032-225	* INSERT			
20	1	1	-			D2571	SADDLE, FWD OUTSIDE			
21	1	<del></del>				D2572	SADDLE, FWD INSIDE			
22	1	1				D2573 1 •	SADDLE, AFT OUTSIDE			
23	7 1	1		<del>                                     </del>		D2574 /	SADDLE, AFT INSIDE			
24	8	8		-		AN4-51A				
25	16	16				D2570 /	BUSHINGS			
26	. 8	. 8				MS21042L4	NUT (OR MS21042-4)			
27	8	.8		1.1		AN6-12A	BOLT			
28	. 8	8		7 11	,	AN960JD616	WASHER			
29	⊋ 16	16				AN4-6A	BOLT			
30	32	. 32				AN960JD416 /	WASHER			
31	. 16	16				MS21042L4	NUT (OR MS21042-4)			
32	4	4				D2747 💆	SET SCREW			
33	2	2				D3533-1	SET SCREW			
40	1	1	<del>                                     </del>			D3407-041	/TOW RING (REPLACES D2968-041)			
41	1	<del>-                                    </del>	<del>                                     </del>	<del> </del>		D3456-1	WASHER			
43	1	1	<del>                                     </del>	<del> </del>	-	MS21043-4	NUT			
44	2	2				D3417-5	WASHER			
		_			<i></i>					
50				<u> </u>	. 1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)			
51					1	D3405-043 :	LUG ASSEMBLY (REPLACES D2736-3)			
52					4	AN4C47A	BOLT			
	ŀ			<u> </u>	8	D2570	BUSHING			
53	<u> </u>									
53 54				<u> </u>	4	MS21043-4	NUT (OR MS21042-4)			
	2	2			4	MS21043-4 D2876	VSADDLE SPACER			

\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

COPYRIGHT © 1996 BY DART AEROSPACE LTD •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **F** 

Date: 08.10.07

W/O:			WC	RK ORDER CHANG	ES						
DATE	STEP	PRO	OCEDURE CHAI	NGE	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
				•							
Part No:		PAR #:	Fault Cate	jory:	_ NCR: Yes	No <b>DQ</b>	A:	Date: _			
							losed: Date:				
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NC	R)					
DATE	CTED	Description of NC		on B	Verific	cation	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	& Secti	on C	Chief Eng	QC Inspector		
M. W.											
	77				• [			1	•		